

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014185**Date Inspected:** 18-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	Orthotropic Box Girder(OBG)		

Summary of Items Observed:

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

BAY-6

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 005769.

Ultrasonic Testing (UT)

This QA performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA generated UT report for this date. The members are identified as OBG Traveler Rail bracket weld Components. Total number of welds UT Tested: 03 No's. The weld designations are review as follows:

1. TR5B-PP69, 67-003.
2. TR6A-PP62-001.

LAY DOWN YARD.

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Segment: 10CW-Panel Point(PP)#92~94.

This QA Inspector along with Caltrans QA Mr. Manikandan performed joint Inspection for the 'T' Rib Horizontal and vertical offset at FL3 Location by using 1000 mm straight edge.

The measured readings were data recorded, generated the report and submitted to the Team Leader for further action.

This QA Inspector along with Caltrans QA Mr. Manikandan performed joint Inspection for the 'T' Rib cope holes buckling areas at FL3 Location by using 150 mm steel ruler.

The measured readings were data recorded, generated the report and submitted to the Team Leader for further action.

TRIAL ASSEMBLY.

This QA Inspector witnessed final Bolt tension verification for the Cable Tray support at Lift:8West from PP#64~65 and 67~68. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed as per the ZPMC submitted Notification No. 00350 Dated: May 18, 2010.

Details of bolt size, RC Set # and final torque value are as follows:

Bolt sizes used were $\frac{3}{4}$ "X2 $\frac{1}{4}$ ", RC Set# DHGM60580 and final torque value was 340 N-m.

Manual Torque wrench was been used with Sr. No. XO2-666.

This QA Inspector witnessed final Bolt tension verification for the Upper and Lower Chevron at Segment:8BW and 8CW from PP#65~71. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed as per the ZPMC submitted Notification No. 00351 Dated: May 18, 2010.

Details of bolt size, RC Set # and final torque value are as follows:

Bolt sizes used were M22X65, RC Set# DHGM220021 and final torque value was 543 N-m.

Bolt sizes used were M22X70, RC Set# DHGM220017 and final torque value was 520 N-m.

Bolt sizes used were M22X75, RC Set# DHGM220034 and final torque value was 453 N-m.

Bolt sizes used were M22X80, RC Set# DHGM220029 and final torque value was 447 N-m.

Manual Torque wrench was been used with Sr. No. XO2-779.

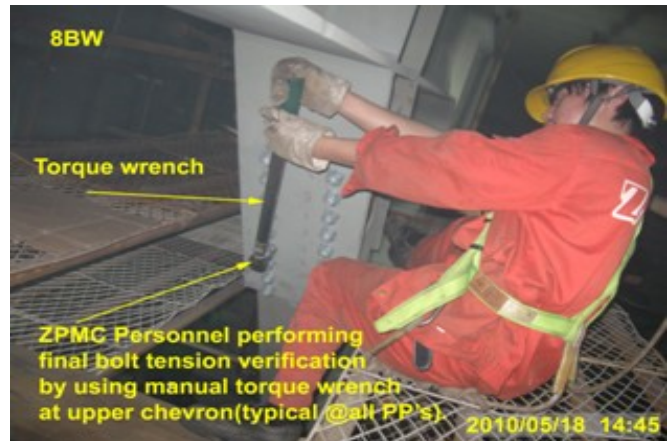
This QA notified ZPMC QC identified as Mr.Hu Mez Gang is present during the inspection.

Refer attached photo for reference.

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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and Quality Control (QC) concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhu,Surendra	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
